



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

order 6256

D350-822-011
Job Sheet R188153



Part No: D350-822-011

Job Qty: 1 ea

Part Name: PA100 PUREair System for AS350/EC130



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No: add DSI 9815-011

Due Date: 1/7/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: IIN-D350-822 REV.H , DSI9815 REV.A IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.18
AS PER IIN REV.C DD VERF:JLM IPP REV:C 15.06.03 AS PER IIN REV.D DD VERF:JLM IPP REV:C
18.07.11 AS PER IIN REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/7/19	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		1/7/19	0.00	0.00	Packaging1-4		
120	QC	1 pcs		1/7/19	0.00	0.00	QC4		
130	Packaging	1 pcs		1/7/19	0.00	0.00	Packaging3-1		
135	DC	1 pcs		1/7/19	0.00	0.00	DC		
140	QC21-FG	1 Ea		1/7/19	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D350-822-011
Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-822-011 CHG005

DAS
21
9-89

JAN 07 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSI 9815-011	Replacement Receptacle	1 pcs (1 ea)	90-Start up Operation	5140509
D350-822-011	PA100 PUREair System for AS350/EC130	1 Ea (1 ea)	110-Packaging	5136833

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSI 9815-011	1	28	0
110-Packaging	D350-822-011	1	7	0

Part Specifications

Specifications could not be found.

new work CB 21308 per DSI 9815

Plex 1/4/19 8:06 AM dart.lacelle.linda

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S142485



Part: D350-822-011

Job No: R188153

Serial No/Batch: S142485

Revision: H/A

Inspector:

Exp Date:

Instructions: TC STC SH14-14 - Issue 2, FAA/STC SR03538NY 15/09/22, EASA

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-822 REV. H AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D350-822 REV. 6 OR LATER APPROVED REVISION

REF. TCCA STC: SH14-14
REF. FAA STC: SR03538NY
REF. ANAC STC: 2014S07-11
REF. JCAB STC: STC-372-OSA/STC-371-OSA
REF. EASA STC: 10056574

1.0 PURPOSE

The purpose of this Service Instruction is to facilitate the replacement of the QD3072-46 Receptacles that are installed on the QB21308 Assembly Screen manufactured by Pall Aerospace as part of the D350-822-011/-013 PA100 PUREair System with the DSI 9815-011 Replacement Receptacle kit. The intent of this DSI has been incorporated into D350-822-011 at CHG 005 and D350-822-013 at CHG 003.

2.0 PROCEDURE

2.1 To install the DSI 9815-011 Replacement Receptacle Kits,

- 2.1.1 Open or remove the Upper Engine Cowl per the Aircraft Maintenance Manual.
- 2.1.2 Remove the Air Intake Seal and the entire QB21308 Assembly Screen by removing qty(22) fasteners per the Aircraft Maintenance Manual. Retain Hardware.
- 2.1.3 Separate the FOD screen from the QB21496 Receptacle by turning the 1/4 turn fasteners and lift the FOD screen per Figure 1.
- 2.1.4 Drill out the retaining rivets and remove qty(4) QD3072-46 Receptacles from the QB21496 Receptacle. Remove any adhesive residue.
- 2.1.5 Position the qty(4) D5713-041 Receptacle Assy in the location shown in Figure 2. Transfer drill 2x $\varnothing 0.098$ " holes with CSK $\varnothing 0.179$ " $\angle 100^\circ$ on the top side from the D5713-041 Receptacle Assy to the QB21496 Receptacle. Touch up holes with Alodine 1200 per MIL-C-5541.
- 2.1.6 Mask nutplate holes and touch up the affected areas with prime and paint per ICA-D350-822.
- 2.1.7 Install qty(4) D5713-041 Receptacle Assy with qty(2) MS20426AD3-(5) Rivets per Figure 2.
5140439
- NOTE: Although not generally necessary, it is acceptable to use longer or shorter MS20426AD3-X Rivets
- 2.1.8 Remove qty(4) 1/4 Turn Fasteners from the FOD Screen per Figure 1.
- 2.1.9 Reinstall the FOD screen on the QB21496 Receptacle using qty(4) AN4-5A bolts and qty(4) NAS1149D0432J Washers per Figure 2. Torque bolts to 50-70 in-lb (5.6-7.9 N-m).
- 2.1.10 Ensure the Engine Intake is clear.
- 2.1.11 Reinstall the QB21308 Assembly Screen between the Engine Intake Duct and the Air Intake Seal using qty(22) fasteners retained at step 2.1.2 per the Aircraft Maintenance Manual.
- 2.1.12 Reinstall the Upper Engine Cowl per the Aircraft Maintenance Manual.
- 2.1.13 Update the Aircraft Log Book to indicate installation of the DSI 9815-011 Replacement Receptacle Kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 18.12.10
CERT. NO.: SH14-14
ISSUE NO.: 2

APPROVED

A	NEW ISSUE	VS	18.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	WK	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9815	SHEET 1 OF 4
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	REPLACEMENT RECEPTACLE	NTS
DATE	18.12.10	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Linda Lacelle

From: Jean-Luc Menard
Sent: Wednesday, January 2, 2019 12:35 PM
To: Linda Lacelle; Chrisoula Tsimiklis
Cc: Ryan Williamson
Subject: Pa100

Br d

Order 0256

Hi Linda,
We will need to ship this kit next Monday with the DSI 9815-011 installed.
Linda, you will need to issue a w/o to pull the current kit and do the install of the DSI.

@Chris,
I called Luc from Bertrand Supply, we will need to send him a po once he sends the quote for the spray paint , paint will be here Friday morning.
JL

Jean-Luc Menard
Director of Operations

DART AEROSPACE
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F 1 613 632-5246
1 800 556- 4166
www.dartaerospace.com



get it completed

43562-01-01
842630-033-15

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Linda Lacelle

From: Steve Ghaleb
Sent: Tuesday, January 29, 2019 6:38 PM
To: Ryan Williamson; Sian Willems
Cc: Jean-Luc Menard; Linda Lacelle; Warran Boyd; Caroline Ashby
Subject: RE: commission

Ryan, Sian,

I agree.

Thanks
Steve

From: Ryan Williamson <rwilliamson@dartaero.com>
Sent: January 29, 2019 6:28 PM
To: Sian Willems <swillems@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Steve Ghaleb <sghaleb@dartaero.com>; Warran Boyd <wboyd@dartaero.com>; Caroline Ashby <cashby@dartaero.com>
Subject: Re: commission

Good point Sian,

I think we should continue to operate as we normally would, commissions and all. To your point we should capture the rework costs on a work order, with a plan to back charge these costs.

@Steve, you agree?

Ryan

Sent from my iPad

On Jan 29, 2019, at 17:36, Sian Willems <swillems@dartaero.com> wrote:

Hi Ryan,

Sorry, I'm not aware of the commission agreement with Pall.

We are currently capturing costs associated with this issue. Would you want any stock reworking to also be captured? Would it make sense to continue to pay the commission on this unit with the expectation that we will try and recoup additional costs from Pall once this issue is completed?

SIAN WILLEMS

Director of Customer Support

DART AEROSPACE

T 1 613 632-3336 > 239

M 1 613 676-0577

From: Ryan Williamson <rwilliamson@dartaero.com>

Sent: Tuesday, January 29, 2019 4:57 PM

To: Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Steve Ghaleb <sghaleb@dartaero.com>; Sian Willems <swillems@dartaero.com>

Cc: Warran Boyd <wboyd@dartaero.com>; Caroline Ashby <cashby@dartaero.com>

Subject: RE: commission

Steve or Sian,

I'm unaware of how this commission process with Pall works, can either of you comment?

Ryan

From: Jean-Luc Menard

Sent: January 29, 2019 16:55

To: Linda Lacelle <llacelle@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>

Cc: Warran Boyd <wboyd@dartaero.com>; Caroline Ashby <cashby@dartaero.com>

Subject: Re: commission

Ryan?

Sent from my iPhone

On Jan 29, 2019, at 4:27 PM, Linda Lacelle <llacelle@dartaero.com> wrote:

JL?

From: Warran Boyd

Sent: Tuesday, January 29, 2019 4:21:51 PM

To: Linda Lacelle; Caroline Ashby; Jean-Luc Menard

Subject: RE: commission

I don't know?

From: Linda Lacelle

Sent: January 29, 2019 2:41 PM

To: Warran Boyd <wboyd@dartaero.com>; Caroline Ashby <cashby@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Subject: commission

Not sure who can answer this – are we still paying commission to Pall on the 1 x D350-822-011 that we had to rework the fod screen???

Job R188153 – order 6256

Pls let me know asap

<image001.png>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-822-011
Job Sheet 183941



Part No: D350-822-011

Job Qty: 1 ea

Part Name: PA100 PUREair System for AS350/EC130



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No: SIOP

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D350-822 REV.H IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.18 AS PER IIN
REV.C DD VERF:JLM IPP REV:C 15.06.03 AS PER IIN REV.D DD VERF:JLM IPP REV:C 18.07.11 AS PER
IIN REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 21 2018
110	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging1-4		
120	QC	1 pcs		10/26/18	0.00	0.00	QC4		
125	Outsource	1 pcs		10/26/18	0.00	0.00	Outsource10		
130	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1		JAN 07 2019
135	DC	1 pcs		10/26/18	0.00	0.00	DC		DAC
140	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		21 JAN 07 2019

Part Op 125 - Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD PO _____ (Send copy of PO to Pall
Descriptions: - James) Issue W/O LINE item for Pall for amount sold on sales order S/O _____ according to sales price see
Warran for amount. (if sale price is \$23,000 - amount is \$13,400) PO can be received immediately and given to finance in
order to close work order.

130 - Identify and pack for shipping as per PPP D350-822-011

135 - Photocopy bluefile & type labels per PPP D350-822-011 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.0401	Pureair Fairing Assembly	1 Ea (1 ea)	90-Start up Operation	5124269
9752100180	Gasket	1 Ea (1 ea)	90-Start up Operation	116596
9945000120	Gasket (for B3e models)	1 pcs (1 ea)	90-Start up Operation	5112872
AN821-12J	Elbow (or AN821-12K or 12S)	2 Ea (2 ea)	90-Start up Operation	5116940
AN929-12J	Cap	1 Ea (1 ea)	90-Start up Operation	5103922
D4925-041	Mounting Plate Assembly	1 Ea (1 ea)	90-Start up Operation	5114065
D4931-1	Engine Fitting (for acft models B2 & previous)	1 Ea (1 ea)	90-Start up Operation	5059439
D4931-3	Engine Fitting (For B3 Models)	1 Ea (1 ea)	90-Start up Operation	5132782
D4931-5	Engine Fitting (for B3e models)	1 Ea (1 ea)	90-Start up Operation	5117908
D4935-1	Mounting Bracket	6 Ea (6 ea)	90-Start up Operation	5110378
D4943-1	Flex Hose	1 Ea (1 ea)	90-Start up Operation	5072110
D4961-041	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5110840
D4961-043	Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5119349
D5079-1	Placard, Eaps	2 Ea (2 ea)	90-Start up Operation	5112849
D5090-041	Duct Assembly	1 Ea (1 ea)	90-Start up Operation	5115819
D5105-1	Handle	2 Ea (2 ea)	90-Start up Operation	5112860

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																								
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																									
Large Fab ☐	Composite ☐	Supplier ☐																																										
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																								
Work Order Deviation		Disposition		Completed By																																								
				Lead hand / Supervisor Approval Verification																																								
				QC / QA Coordinator Approval																																								
FAULT CATEGORY																																												
<table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Pressure/Forced</td> <td style="border: none;">☐ Temperature/Cure</td> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Bending</td> <td style="border: none;">☐ Set-up</td> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Centre Not Concentric</td> <td style="border: none;">☐ BOM/Route</td> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Cracks</td> <td style="border: none;">☐ Broken/Damage/Defect</td> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td> <td style="border: none;">☐ Inspection Incomplete/Unqualified</td> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Cuffs</td> <td style="border: none;">☐ Contamination</td> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Crushing</td> <td style="border: none;">☐ Countersink</td> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Heat Treat</td> <td style="border: none;">☐ Cut Too Short</td> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Wave/Twist in Tube</td> <td style="border: none;">☐ Instructions Incomplete/Unclear</td> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Marks/Chatter</td> <td style="border: none;">☐ Drill Holes</td> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>					☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
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OTHER : _____																																												

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hackensack, NJ 07641
 CANADA 512 632-5200
 TEL: sales@dartaero.com
 Email: dartaero.com



Container No: S136833



Part: D350-822-011

Job No: 183941

Serial No/Batch: S136833

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH14-14 - Issue 2, FAA STC SR03531

Eq

H

material

Internal Transport

Tribal Knowledge

LOA

Substation

Past Expiry Date

Misidentified

Use for Testing

Poor Information

Rushing

Product Improvement

Process Improvement

Manufacturing Process

Past Due

Pressure/Forced

Bending

Centre Not Concentric

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Temperature/Cure

Set-up

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Power Loss/Surge

Folio/Program

Grain

Weld

Wrong Stock Pulled

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

OTHER :

D5110-1	Swivel Nut Fitting	1 Ea (1 ea)	90-Start up Operation	5047165
D5179-1	Doubler	2 Ea (2 ea)	90-Start up Operation	5118674
D5179-3	Doubler	2 Ea (2 ea)	90-Start up Operation	5118072
D5194-1	Doubler	2 Ea (2 ea)	90-Start up Operation	5122034
D5208-041	Blanking Plate Assembly	3 Ea (3 ea)	90-Start up Operation	5116998
LN9038-05012	Bolt 5116942X1	36 pcs (36 ea)	90-Start up Operation	510405920 5116052X 15
LN9038-05040	Bolt	1 pcs (1 ea)	90-Start up Operation	5119802
LN9348-05	Nut	32 pcs (32 ea)	90-Start up Operation	5117991
MS20470AD3-4	Rivet, Universal Head	18 Ea (18 ea)	90-Start up Operation	FM13665-60
MS21919WCH12	Clamp	1 Ea (1 ea)	90-Start up Operation	5115303
MS9592-138	Bracket	1 pcs (1 ea)	90-Start up Operation	5014155
NAS1149D0332J	Washer	70 Ea (70 ea)	90-Start up Operation	5113257
NAS43DD3-64	Spacer	1 Ea (1 ea)	90-Start up Operation	5116952
22208CM050016E	Screw	2 pcs (2 ea)	90-Start up Operation	5115291
23350CA050	Washer	2 Ea (2 ea)	90-Start up Operation	5013736
9945000160	Gasket	1 Ea (1 ea)	90-Start up Operation	5115264
D5526-1	Upper Hose Protector	1 Ea (1 ea)	90-Start up Operation	5118043
D5526-3	Lower Hose Protector	1 Ea (1 ea)	90-Start up Operation	5118052
LN9038-05016	Bolt	2 pcs (2 ea)	90-Start up Operation	FM132469
BS4320-A5	Washer	56 Ea (56 ea)	110-Packaging	5111509
LN29985-A05	Anchor Nut	15 pcs (15 ea)	110-Packaging	M134946
LN9038-05018	Bolt	56 pcs (56 ea)	110-Packaging	381717
MS20426AD3-3	Rivet	40 Ea (40 ea)	110-Packaging	5111514
QB21304	Pureair Panel Assembly	1 pcs (1 ea)	110-Packaging	5111504
QB21308	Fod Screen Assembly	1 pcs (1 ea)	110-Packaging	5111505
QB21310	Transition Duct Assembly	1 pcs (1 ea)	110-Packaging	5111506
QR10616	Vortex Tube Repair	1 pcs (1 ea)	110-Packaging	5111510
LN9038-05016	Bolt	2 pcs (2 ea)	110-Packaging	5132469

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22208CM050016E	2	12	0
	23350CA050	2	22	0
	650.0401	1	2	0
	9752100180	1	10	0
	9945000120	1	18	0
	9945000160	1	7	0
	AN821-12J	2	32	0
	AN929-12J	1	12	0
	D4925-041	1	9	0
	D4931-1	1	12	0
	D4931-3	1	8	0
	D4931-5	1	8	0
	D4935-1	6	60	0
	D4943-1	1	13	0
	D4961-041	1	8	0
	D4961-043	1	7	0
	D5079-1	2	16	0
	D5090-041	1	4	0
	D5105-1	2	18	0
	D5110-1	1	12	0
	D5179-1	2	17	0
	D5179-3	2	18	0
	D5194-1	2	13	0
	D5208-041	3	8	0
	D5526-1	1	4	0
	D5526-3	1	2	0
	LN9038-05012	36	270	0
	LN9038-05016	2	30	0
	LN9038-05040	1	2	0
	LN9348-05	32	85	0
	MS20470AD3-4	18	6,437	0
	MS21919WCH12	1	7	0
	MS9592-138	1	13	0
	NAS1149D0332J	70	2,386	0
	NAS43DD3-64	1	12	0
110-Packaging	BS4320-A5	56	174	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

LN29985-A05	15	207	0
LN9038-05016	2	30	0
LN9038-05018	56	878	0
MS20426AD3-3	40	3,533	0
QB21304	1	3	0
QB21308	1	3	0
QB21310	1	4	0
QR10616	1	7	0
Part Specifications			
Specifications could not be found.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								